	W	ork	Orde	er ID	59224
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Friday, May 28, 2010 9:46:36 AM



Page 1

Item ID:

D3786-1

Accept



Setup Start

Stop



Revision ID:

Item Name:

Sleeve

5/27/2010 Start Qty: 4.00

Req'd Qty: 4.00

Cust Item ID: Customer:

Reference:

Start Date:

Process Plan: Approvals:

Date: 10 5-2

Tooling:

Date:

Run

Start



Required Date: 6/4/2010

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ **Work Center ID** Operation Description

Set Up/ **Run Hours**

Tool ID

Tool # Plan Code

Accept Qty

Reject Reject Qty Number

Insp. Stamp

Draw Nbr

Revision Nbr

D3786

Rev A

100

Doosan

DOOSAN LATHE

0.00

0.00

Doosan Lathe

per dwg D3786

JL 10/05/31

110

QC2- Inspect parts off machine FAI/FAIB

0.00

Quality Control

Memo

0.00

120

QC8- Inspect parts - second check

0.00

0.00

It 10/04/31

Memo Quality Control

W/O:		WORK ORDER CHANGES												
DATE	STEP	PRO	OCEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
		·												
							····		4 .					
Part No				NCR: Yes No DQA: Date:										
	R	esolution:							Date:					
NCR:			NORK ORE	DER NON-CONFO	DRMANCE	(NCR)							
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Action Descri	Section B ption	Sign & Date	Verific Secti		Approval Chief Eng	Approval QC Inspector				
			- Julia Lug	Office Eng		Date								
							·							
						,								

Work Order ID 59224

Friday, May 28, 2010 9:46:36 AM



Page 2

Item ID:

D3786-1

Accept

Setup Start



Revision ID:

Start Date:

Sleeve Item Name:

Required Date: 6/4/2010

5/27/2010

Start Qty: 4.00

Req'd Qty: 4.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: _____

QC:

Date:_____

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Start Run

Stop

Stop



Sequence ID/ Work Center ID

130

HandFinish

Operation Description

Chemical Conversion Coat per QSI005 4.1

Set Up/ **Run Hours**

0.00

0.00

Tool ID

Tool # Plan Code Accept Qty

Reject **Qty**

Reject Number Stamp

Insp.

Hand Finishing

OC3- Inspect Part Finish

0.00

0.00

140

QC

Quality Control

Memo

Memo

150

Packaging Packaging

Identify as per dwg & Stock Location: 299

Memo

0.00

0.00

Dart	Aeros	pace	Ltd
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W/O:		WORK ORDER CHANGES												
DATE	STEP	PRO	PROCEDURE CHANGE				Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
							:							
	:	·												
		PAR #:												
		esolution:								Date:				
NCR:			WORK OR	DER NON	-CONFORM	IANCE	(NCR)						
DATE	STEP	Description of NC Section A	Initial Corrective Action Section In Action Description				Sign &	Verific		Approval	Approval			
		Section	Chief Eng	7.00	Chief Eng		Date	Secti	on C	Chief Eng	QC Inspector			
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Worl	k O	rder	ID	59224
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Friday, May 28, 2010 9:46:36 AM



Page 3

Item ID:

D3786-1

Accept



Setup Start

Stop



Revision ID:

Start Date:

Item Name: Sleeve

Required Date: 6/4/2010

5/27/2010

Start Qty: 4.00

Req'd Qty: 4.00



Cust Item ID: Customer:

Reference:

Quality Control

Approvals:	Process Plan:	Date:Date:	Tooling: SPC (Y/N):		ate:		R	tun Sta Sto		
Sequence ID/ Work Center II	Opera Descr		Set Up/ Run Hours	Tool ID	Tool#	Pian Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
	QC21-	Final Inspection - Work Order Release	0.00						106/0	ĴΛ
QC		Memo	0.00						1 - 4 10	

CX10/6/12

W/O:		WORK ORDER CHANGES											
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty Appro	ing / Approvar					
		·											
		PAR #:	Fault Ca	tegory:	NCR: Yes No DQA: Date:								
Resolution:			Disposit	ion:	QA: N/C C	losed:	Dat	te:					
NCR:			WORK OR	DER NON-CONFORM	ANCE (NCI	R)							
DATE	STEP	Description of NC		Corrective Action Section B			ion Appro	oval Approval					
DAIL	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	Section							
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Picklist Print

Friday, May 28, 2010 9:46:40 AM

Work Order ID: 59224

Parent Item:

D3786-1

Parent Item Name:

Comments:

Item Name

Sleeve

Item ID

IPP Rev:A 08-05-20

Replacement Mfg/

Purch

Purchased

new issue DD verified by:EC

IPP Rev:B 08-06-17 rev.A as per dwg DD verified by:EC

Last

No

Bin Primary Item Location

Location

Route Seq ID 110

Unit of Measure f

Qty on Hand 79.0000

Qty per Kit

0.1667

Start Qty: 4.00

Start Date: 5/27/2010

Total Otv 0.701895

Qty **Issued**

Issued

Required Qty: 4.00

Date Status

Component Item ID/

M6061T6T1.000W065

6061T6 RD TUBE 1.00 x .065w

Location MAT015

113511

114089

Loc Qty 79

67 12 Loc Code

Required Date: 6/4/2010

Page 1

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W/O:			WORK ORDER CHANGES										
DATE	STEP	PROC	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector						
		PAR #:	Fault Category: NCI			NCR: Yes No DQA: Date:							
		olution:	Dispositi	on:	QA: N/C CI	osed:		Date: _					
NCR:		Wo	ORK ORE	DER NON-CONFORMA	NCE (NCF	R)							
DATE	STEP	Description of NC		Corrective Action Section		Verific	ation	Approval	Approval				
	Section A		Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Secti		Chief Eng	QC Inspector				
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DART AEROSPACE LTD	Work Order:	59224
Description: Sleeve	Part Number:	D3786-1
Inspection Dwg: D3786 Rev: A		Page 1 of 1

	FIRST	ARTICLE IN	SPECTION	ON CHE	CKLIST		
	X	First Artic	le	Proto	otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Coi	mments
Ø0.985	+0.000/-0.010	979					
0.058	+/-0.010	.057					
0.03 x 45°	+/-0.030 x +/-0.5°	.03x45°	/			•••	-
2.00	+/-0.030	1.999					<u> </u>
1.10	+/-0.030	1.10	//				
0.38	+/-0.030	-380					
Ø0.323	+0.006/-0.001	.324					
	·						
4.							
AF Land							
asured by:	ンL 「	Audited by:	SF		Prototype Appr	oval:	N/A
Date:	10/05/31	Date:	0/05/31		<u> </u>	Date:	N/A
v Date 08.07.25	Change New Issue		/ /=		Revised KJ/DD	by .	Approve

H:\FORMS\Quality	Assurance\approved	QA\FAI revD
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W/O:		WORK ORDER CHANGES												
DATE	STEP	PROC	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector							
Part No		PAR #:	Fault Cate	egory:	NCR: Yes No DQA: Date:									
Reso		solution:	Disposition	on:	QA: N/C CI	osed:		Date:						
NCR:		W	ORK ORD	ER NON-CONFORM	ANCE (NCF	R)								
DATE	STEP	Description of NC Section A	Initial Action Description Chief Eng Chief Eng		stion B Sign & Date	Verification Section C		Approval Chief Eng	Approval QC Inspector					
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Ø0.985^{+0.000} -0.010 0.058 REF SHOP COPY **RETURN TO ENGINEERING** UNCONTROLLED COPY -0.03 X 45° CHAMFER 2 PL SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER NO. 59224 Plo -5-28 2.00 1.10 0.38 Ø0.323 THRU 2 PL

D3786-1 SLEEVE

NOTES:
1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING (1.000 X 0.065 WALL) PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 (REF. DART SPEC. M6061T6T1.000W.065)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.03 lbs

Α	NEW IS	SUE	HS	08.06.04			
REV.			DESCRIPTION	BY	DATE		
DESIGN HS		HS	DART AEROSPACE LTD				
DRAWN		HS	HAWKESBURY, ONTARIO, CANADA				
CHECKED		84/	DRAWING NO.		REV. A		
MFG. APPR.		LA	D3786		SHEET 1 OF 1		
APPROVED 1		1096	TITLE		SCALE		
DE API	DE APPR		SLEEVE		NTS		
DATE 08.06.04			COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRAVE AND COMPRISHING HIS BUMPLED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OF ONE DO BY COMPRISHED TO ANY OTHER PURPON WETHOUT WAITTEN PURPOSE WITHOUT PROBLEMS OF MEMORY AND ANY ASSOCIATION.				

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W/O:			WC	ORK ORDER CHANG	ES				•	
DATE	STEP	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
							-			
							:			
Part No: PAR #:		PAR #:	Fault Cate	_ NCR: Yes	CR: Yes No DQA: Date:					
· ·			Disposition	Disposition: Q			QA: N/C Closed: Date:			
NCR:			WORK ORDI	ER NON-CONFORMA	ANCE (NC	R)		·		
DATE ST	STEP	Description of NC	·	Corrective Action Section B		Verifi	cation	Approval A	Approval	
	JIL.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date		Section C	Chief Eng	QC Inspector	
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